

Work Order ID 119160

May-12-14 9:57:30 AM

slip 22/05 x1

119160

Page 1

Item ID: K591-113 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Short Step Instln
 Start Date: 5/12/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
DSI9525	A								

104	Pick Kit	0.00				2x		14-05-22	
104									
Packaging	Memo	0.00				2x		14-5-13	
Packaging									

105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.00				2		14-05-22	
Quality Control									

110	Identify as per dwg & Stock Location: _____	0.00							
110									
Packaging	Memo	0.00				2		14-05-22	
Packaging	***CHG005***								

DAS
26
9:38

Work Order ID 119160

May-12-14 9:57:30 AM

119160

Page 2

Item ID: K591-113

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Short Step Instln

Start Date: 5/12/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

14/5/22

ME

14-5-22

Picklist Print

May-12-14 9:57:28 AM

Page 1

Work Order ID: 119160

119160

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 5/12/14

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C04.11.09ReformatKJ/JLM
as per revG DD 10.04.20 verified by:EC
586 10.06.18 DD verf:EC

IPP Rev:D
IPP Rev:E as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 2 *D2171* Clamp		Manufactured	No			104	Each	28.0000	2 4	4		5/15/14	DAS 26 9-89
	DAS 31 9-89				Location ST456			28					
					113371			28					
D2274 2 *D2274* Radius Block		Manufactured	No			104	Each	290.0000	4 8	8			DAS 26 9-89
	DAS 31 9-89				Location FG			12					
					86855			12					
					ST008			278					
					109534			18					
					110264			2					
					112466			258					
D2182B 2 *D2182B* Seal(\$Per Foot)		Manufactured	No			104	f	392.4700	0.5833 22	22			DAS 26 9-89
	DAS 31 9-89				Location ST412			392.47					
					101827			1					
					108914			43.47					
					115189			348					

(D2182B035) CUT 2 AT 3.50"

Picklist Print

May-12-14 9:57:28 AM

Page 2

Work Order ID: 119160

119160

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 5/12/14

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

DAS
26
9-89

4 D2362-3 Manufactured No 104 Each 0.0000

2 ***D2362-3*** DAS
Step Support Bracket 31
D3595-200-300 9-89

1 2

**

117814

Manufactured No 104 Each 5.0000

2 ***D3595-200-300***
Rubber Cushion

1 2

**

B 119160

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

5

84209

5

AN3-37A

Purchased No

104 Each 120.0000

2 4

**

DAS
26
9-89

2 ***AN3-37A***
Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

ST353

110

123355

110

AN4-21A

Purchased No

104 Each 41.0000

4 8

**

14-5-B DAS
26
9-89

2 ***AN4-21A***
Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

ST516

41

m127817

41

8x

May-12-14 9:57:29 AM

Shop Packet Print

Page 2

Picklist Print

May-12-14 9:57:29 AM

Page 3

Work Order ID: 119160

119160

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 5/12/14

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

AN4-22A

Purchased

No

104

Each

333.0000

1 2

**

DAS
26
9-89

2 *AN4-22A*
Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

GA	50	
116419	50	
ST515	2	
118628	2	
ST516	281	
120930	31	2x
123348	100	
m128403	150	

NAS1149D0363J

Purchased

No

104

Each

4,394.000

4 8

**

DAS
26
9-89

2 *NAS1149D0363J*
Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

GA	23	
124392	23	
ST510a	4371	
m126319	7	
m128429	4364	8x

NAS1149D0463J

Purchased

No

104

Each

6,592.000

6 12

**

DAS
26
9-89

2 *NAS1149D0463J*
WASHER

DAS
31
9-89

Location

Loc Qty

Loc Code

ST510a	6592	
M126221	20	
M127813	22	
M127904	3000	
M128591	2050	12x
M128995	1500	

May-12-14 9:57:29 AM

Shop Packet Print

Page 3

Picklist Print

May-12-14 9:57:29 AM

Page 4

Work Order ID: 119160

Parent Item: K591-113

Parent Item Name: Short Step Instln

119160

K591-113

Start Date: 5/12/14

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

104

Each

7,418.000

2 4
**

DAS
26
9-89

2 *MS21042L3*
Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST314

463

M127410

13

M127831

41

M128401

409

ST506

955

123900

955

ST509

6000

M128754

6000

MS21042L4

Purchased

No

104

Each

7,010.000

5 10
**

DAS
26
9-89

2 *MS21042L4*
Locknut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST314

44

m126015

12

m126275

32

ST509

6955

m127255

71

m127813

988

m128300

896

m128798

5000

ST518

11

m127376

11

May-12-14 9:57:29 AM

Shop Packet Print

Page 4

REFERENCE ONLY

DAS

31

9-89

14-05-22

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	4	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 10.06.08

CERT. NO.: SH92-6

ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	9	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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REFERENCE ONLY

DART AEROSPACE LTD.

DAS
31
9-99

D350-591
Page 22 of 23

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	Heli-Access-Step ™, Long Step – High Skid
	X					D350-591-113	Heli-Access-Step ™, Short Step – High Skid
		X				D350-591-115	Heli-Access-Step ™, Short Step – Low Skid
			X			D350-591-117A	Heli-Access-Step ™, Pre-Flight Step
				X		D350-591-119	Heli-Access-Step ™, Long Step – Low Skid
					X	D350-591-133	Heli-Access-Step ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4	4	4	1	AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-122	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-123	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-124	Heli-Access-Step ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G
Date: 08.10.06

Work Order ID 119160

May-12-14 9:57:30 AM

119160

Page 1

Item ID: K591-113 Accept *N900040100* Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Short Step Instln

Start Date: 5/12/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
DSI9525	A	<u>MLJ</u>							
104	Pick Kit	0.00							
104									
Packaging	Memo	0.00							
Packaging									
105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.00							
Quality Control									
110	Identify as per dwg & Stock Location: _____	0.00							
110									
Packaging	Memo	0.00							
Packaging	***CHG005***								

MLJ 14-05-13 (2)
2X 14-5-13
DAS 26 9:39